

Work Order ID 65184

Friday, January 07, 2011 10:38:55 AM



Page 1

Item ID: D350-591-216

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short RH

Start Date: 1/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-01-7

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3168

Rev A

DSI 9472

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-216 CHG003

8.16.126

HJ for BG 11-01-25

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168
2-Drill extrusion as per Dwg D3168 using Jig DT8680 for rivets.(Use only 1st 6holes)
3-Deburr

K 11-01-14

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Revision ID:					Stop	
Item Name:	Heli-Access-Step, Short RH					
Start Date:	1/7/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	1/14/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Silva</i>		<i>42</i>			
130 Large Fab Large Fab	Large Fab Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8780, weld Fwd End Plate as per QSI 004 & Dwg D3168 A/R Aluminum Rod <i>M108436</i> 3-Grind End Plate flush <i>M115928</i>	0.00 0.00		<i>FE 11.01.17</i>		<i>2</i>	<i>0</i>		
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<i>2</i>	<i>0</i>	<i>FE 11/01/13</i>	

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sub 1/18		x2 RM			
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		=> H 11/01/15		(2RH) 0			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		H 11.01.20		2 0			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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[illegible]

Page 4

Accept

[illegible]**Setup Start**

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Stop

**Insp.
Stamp**

0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

Rivet Leg Assembly as per Dwg D3168

190

100-443887-100

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

200

Abstract

Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Bevel Aft end for welding
2-Inspect for foreign object as per QSI 024
3-Weld Aft End Plate as per QSI 004 & Dwg D3168
A/R Aluminum Rod M108436
4-Grind End Plate flush

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

2 0 BE 1/6/20

220

QC5- Inspect part completeness to step on W/O

0.00



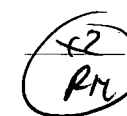
QC

Memo

0.00

Quality Control

Sub 1/20



230

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BR 11-01-20

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

m

Memo

0.00

Powder Coating

START TIME:

2:25

OVEN TEMPERATURE:

320°

FINISH TIME:

2:55

2 *BF* *11-01-20*

250

Pressure Wash per QSI005 4.3

0.00



HandFinish

11.01.21 perm. chg

Wing Work

Memo

0.00

Hand Finishing

=> ML - 11/01/21

X2

Ø

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/01/26

42

147

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Pick Kit	0.00							
Packaging	Memo	0.00				11/1/25		SP	(20)
Packaging									
280	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00				42			
Quality Control						RH			
290		0.00							
Packaging	Packaging	0.00				11/1/26		SP	(20)
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-216								
	Location: <u>61</u>								
	PPP Rev: <u>2</u>								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/26
CL11/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, January 07, 2011 10:39:00 AM

Page 1

Work Order ID: 65184

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 02.10.17 New issue KJ
IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21042L4



Nut

Purchased

No

110

Each

5,072.000

6

12

11.1.17

Location

Loc Qty

Loc Code

ST300

5072

1123143

2

115589

10

115621

560

116188

3500

116548

1000

D3067-1



End Plate

Manufactured

No

130

Each

116.0000

1

2

11.01.17

Location

Loc Qty

Loc Code

WA

116

60141

2

62664

6

63550

108

D3170-1



Spacer

Manufactured

No

130

Each

35.0000

2

4

11.01.19

Location

Loc Qty

Loc Code

Mezz

325113

35

35824

35

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 65184

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Parent Item Name: Heli-Access-Step, Short RH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D3077-1

Manufactured No

180 Each

34.0000 2 4



Step Leg



11.01.19

Location

Loc Qty

Loc Code

WA

34

26684

10

35817

24

4

D3169-1

Manufactured No

180 Each

15.0000 1 2



Support



11.01.17

Location

Loc Qty

Loc Code

WA

15

26685

15

2

MS20600-AD4W4

Purchased No

180 Each

2,351.000 12 24



11.01.19

Rivets

Location

Loc Qty

Loc Code

ST321

2351

113368

38

114181

11

114718

2

115573

147

115640

31

116022

622

116188

1500

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D3067-1

Manufactured No

200

Each

116.0000

1

2



End Plate



11.01.20

Location

Loc Qty

Loc Code

WA

116

60141

2

62664

6

63550

108

Purchased

No

270

Each

168.0000

2

4

AN3-35A



Bolt



11.12.50

Location

Loc Qty

Loc Code

ST353

168

116191

100

116419

18

116549

50

Purchased

No

270

Each

300.0000

6

12

AN4-11A



Bolt



11.12.50

Location

Loc Qty

Loc Code

ST357

300

110382

100

115316

200

Purchased

No

270

Each

265.0000

4

8

AN4-13A



Bolt



11.10.09 11.12.50

Location

Loc Qty

Loc Code

ST357

265

116191

265

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Shop Packet Print

Page 3

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Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-16A

Purchased

No

270

Each

154.0000

4

8



Bolt

Location

Loc Qty

Loc Code

ST358

100

116400

100

ST360

54

115422

54

AN960JD10

NAS1149D0363J

Purchased

No

270

Each

8.0000

4

8



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD416

NAS1149D0463J

Purchased

No

270

Each

30.0000

12

24



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

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Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D2230-1

Manufactured No

270 Each

166.0000

2

4



Lug

Location

Loc Qty

Loc Code

ST430

80

63998

80

ST476

86

62665

2

63319

4

64423

80

D2230-3

Manufactured No

270 Each

94.0000

2

4



Lug

Location

Loc Qty

Loc Code

ST476

94

55452

2

63312

12

64422

80

D2622-120C

Manufactured No

270 Each

17.7000

0.5

1



Step Extrusion

Location

Loc Qty

Loc Code

WA

17.7

55214

3.42

58544

1

61208

13.28

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Start Qty: 2.00

Required Qty: 2.00

D2732

Manufactured No

270 f

571.8793 0.5 1



Rubber Extrusion



1/1/2011

S2 x 1 per kit @ 30" → measure 8 u/lr/20

Location

Loc Qty

Loc Code

ST410

500

64283

500

ST412

71.879279

56516

71.879279

270 f

275.2930 0.6 1.2

D2856-400

x 1 per kit @ 7.20"

Manufactured No



Abraison Strip



1/1/2011

S2

measure 8 u/lr/20

Location

Loc Qty

Loc Code

ST403

275.2930421

56626

0.00004211

59920

59.293

63735

216

270 Each

3,282.000 *52*

MS21042L3

S2



Nut



1/1/2011

Location

Loc Qty

Loc Code

ST300

3282

114784

9

115835

773

116391

900

116540

800

116549

800

4

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DESIGN <i>ap</i>	DRAWN BY <i>ap</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3168	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *1*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *45184* *8/11-01-7*

Part No.	Description	QTY -041	QTY -042
D3168-041	Step Assembly, Low Short (LH)	X	
D3168-042	Step Assembly, Low Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3067-1	END PLATE	2	2
D3077-1	STEP LEG	2	2
D3169-1	SUPPORT	1	1
D3170-1	SPACER	2	2
MS20600AD4W4	RIVET	12	12

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3169-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

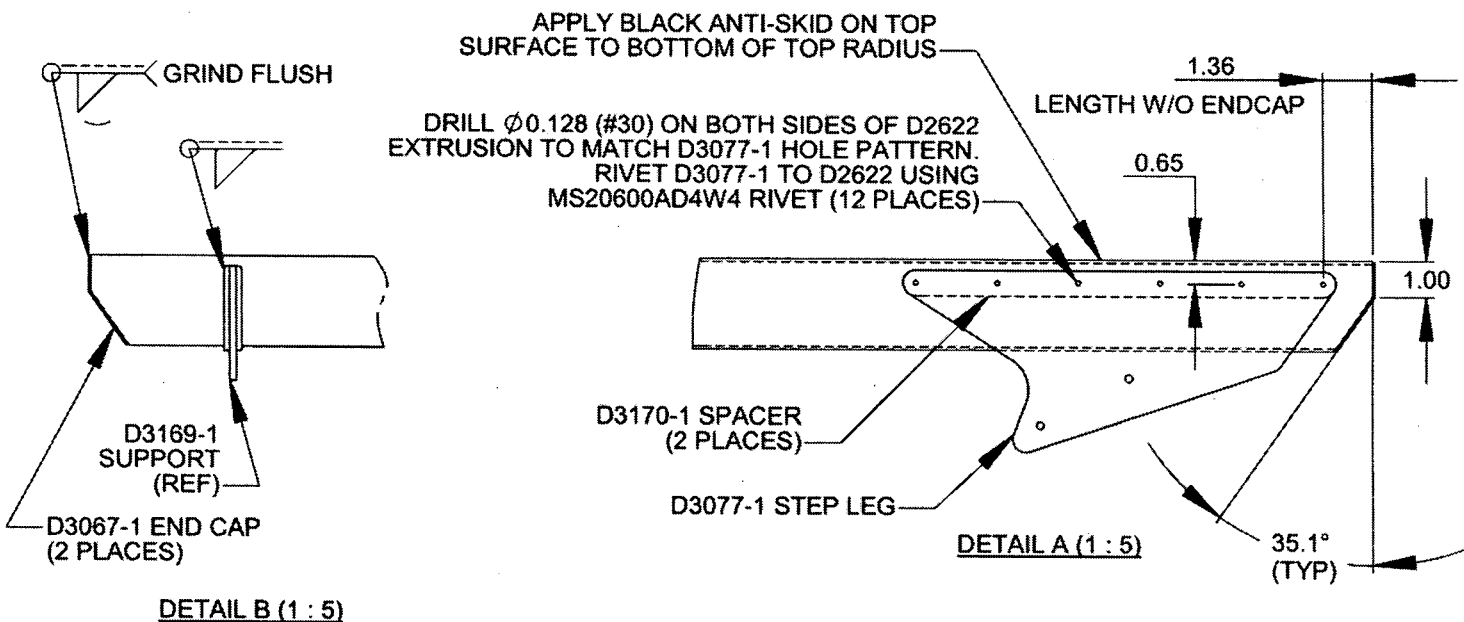
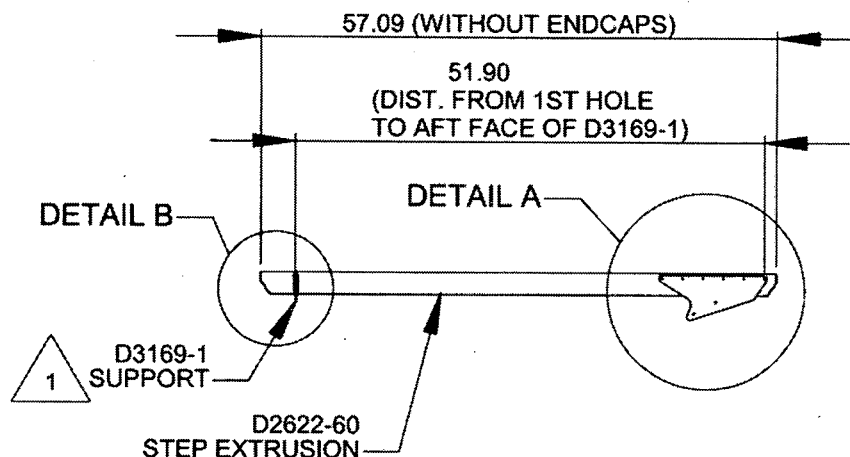
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
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CHECKED	APPROVED	DRAWING NO. D3168
DATE		REV. A
02.09.11		SHEET 2 OF 2
	TITLE	SCALE
	STEP ASSEMBLY, LOW SHORT	1:20

RELEASED
02.09.2011

u/o 65184



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

u/o 65184

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>92</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>UP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>NCA</i>	DSI 9472	SHEET 1 OF 2
APPROVED	<i>AN</i>	TITLE	SCALE
DE APPR.	<i>AN</i>	BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

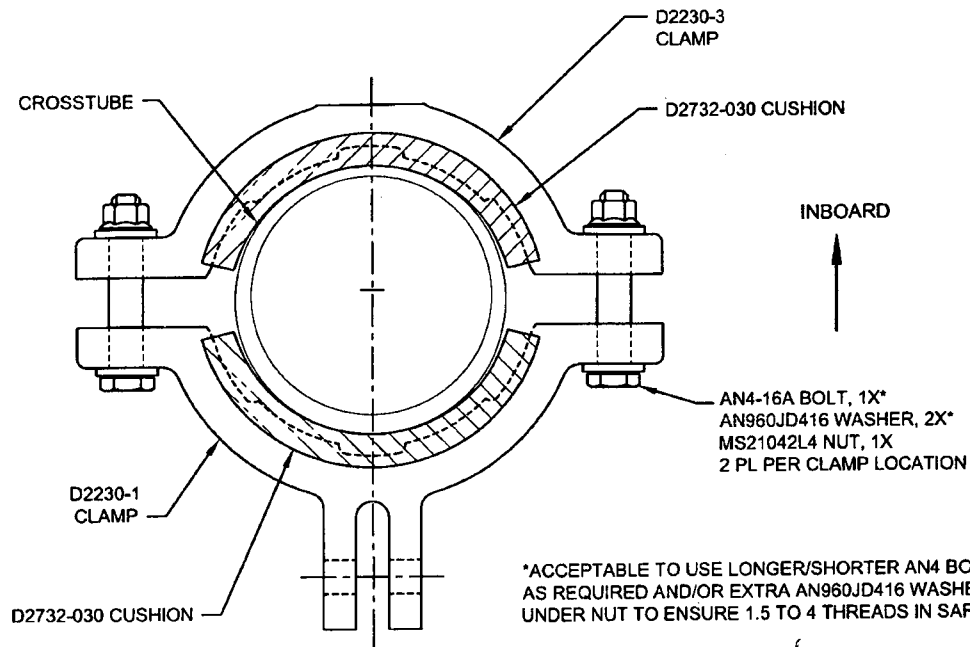
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



u1065184

FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	<i>g</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>g</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT ADDITION	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

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AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
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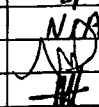

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X			/	D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X		/	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X	/	D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
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